

Date: Friday, 11/07/2008 10:25:16 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOUBLER
Job Number	: 40437		
Estimate Number	: 10892		
P.O. Number	:	Part Number	: D32861
This Issue	: 11/07/2008 S.O. No. :	Drawing Number	: D3286 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : SMALL / MED FAB	Drawing Revision	: A
Previous Run	: 33895	Material	:
Written By	:	Due Date	: 31/07/2008 Qty: 20 Um: Each
Checked & Approved By	: <u>JUD 08-7-11</u>		
Comment	: Est A 04.07.14 New issue KJ/JLM Est Rev:B Now on Waterjet 06-06-16 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S11GA	304/316 .125 Sheet
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Comment: Qty.: 0.0786 sf(s)/Unit Total : 1.5729 sf(s)

304/316 .125 Sheet

Batch: 108156 RB 8-7-14

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3286

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary RB 8-7-14

(22)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

S 08/07/15 (22) counter

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

Form as per Dwg D3286

RB 08/07/14 (22)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes, No, DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 11/07/2008 10:25:16 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 40437

Part Number: D32861

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

So 8/7/16 (22) Carter

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

P 8/7/16 19 + 3 Jimmy = 22

8.0

QC21 -

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/17

Job Completion



MF 08-07-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

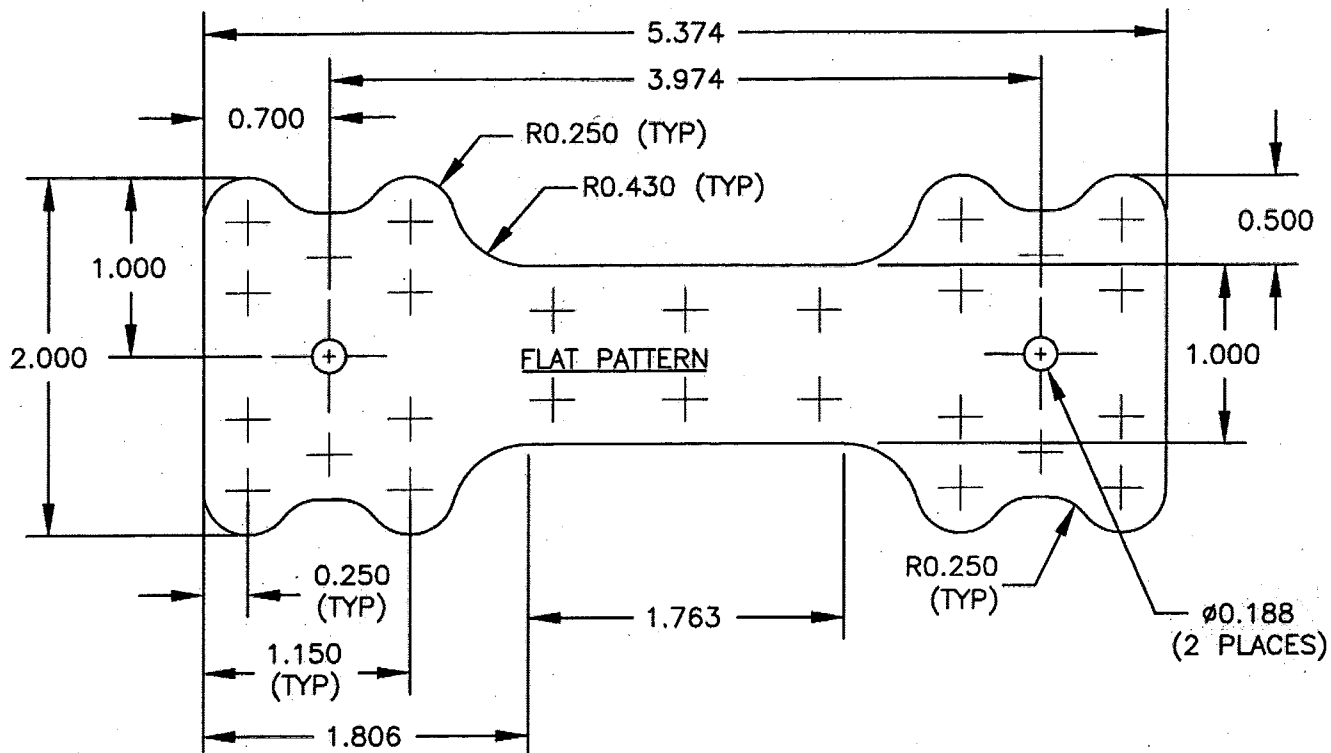
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>UP</i>	DRAWN BY <i>UP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3286	REV. A SHEET 1 OF 2
DATE 04.05.06		TITLE GROUND HANDLING PARTS	SCALE 1:1
A	04.05.06	NEW ISSUE	



+ INDICATES LOCATION OF RIVET HOLES. SHOWN FOR REFERENCE ONLY, DO NOT DRILL.

BENDING DETAIL

R1.51

RELEASED
04.06.22

D3286-1 DOUBLER

- 1) MATERIAL: AISI 304/316 SS SHEET 0.125" THICK
(REF DART SPEC. M304S11GA)
- 2) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

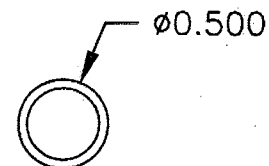
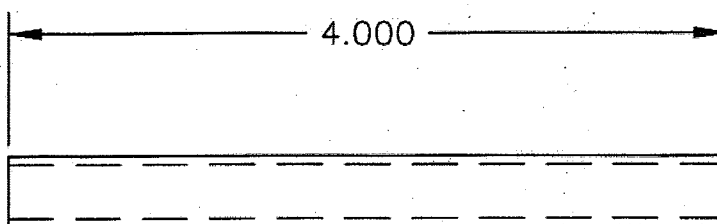
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3286	REV. A SHEET 2 OF 2
DATE 04.05.06		TITLE GROUND HANDLING PARTS	SCALE 1:1



D3286-3 SPACER

- 1) MATERIAL: AISI 304/316 SS TUBING, 0.500 O.D. x 0.049 WALL
(REF DART SPEC. M304TR0.500W.049)
- 2) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED
04.06.22 *[Signature]*

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